

PATENT CLAIMS

1. A method for producing a clip-on fastening system in which a fastening element (2) that functions as the base part of the clip-on fastening system is connected in a non-positive manner to a substrate (1), said fastening element serving to provide a detachable clip-on fastening of the substrate (1) to a component (4), in particular a gasket which is provided with a clip area (5), whereby the fastening element has a cross-sectional shape corresponding to the clip area (5) of the component (4), characterized in that a fastening element (2) already prefabricated and manufactured as a hardened continuous profile using a hard material in an extrusion process is glued to the substrate (1), and the component (4) is clipped with the clip area (5) onto the finished fastening element (2).
2. The method according to Claim 1, characterized in that the hardened continuous profile is produced in-line with the process step of gluing the fastening element (2) onto the substrate.
3. The method according to Claim 1, characterized in that the continuous profile is wound up onto a roll before glue application and is unwound from the roll for the purpose of glue application.
4. The method according to any one of the preceding Claims 1 through 3, characterized in that the continuous profile is pressed against the substrate (1) with a pressure roller when gluing it to the substrate.
5. The method according to any one of the preceding Claims 1 through 4, characterized in that a double-

sided adhesive tape (3) is applied to the underside of the continuous profile.

6. The method according to any one of the preceding Claims 1 through 4, characterized in that an adhesive is applied to the underside of the continuous profile.
7. The method according to any one of the preceding Claims 1 through 4, characterized in that an adhesive is applied to the underside of the continuous profile and to the substrate.
8. The method according to any one of the preceding Claims 1 through 4, characterized in that shortly before bringing the continuous profile in contact with the substrate, it is heated on the surface that is to be glued.
9. The method according to any one of the preceding Claims 1 through 8, characterized in that a thermoplastic material is used as the material for the fastening element (2).
10. The method according to any one of the preceding Claims 1 through 8, characterized in that a thermoplastic elastomer is used as the material for the fastening element (2).
11. The method according to any one of the preceding Claims 1 through 8, characterized in that polyurethane is used as the material for the fastening element (2).
12. The method according to any one of the preceding Claims 1 through 11, characterized in that a material that is also hard is used as the material for the clip area (5).

13. The method according to Claim 1 and/or 12, characterized in that a material having a hardness of at least 40 Shore D, preferably 45 Shore D is used.
14. The method according to Claim 1, characterized in that the component (4) is also prefabricated as a continuous profile.
15. The method according to any one of the preceding Claims 1 through 14, characterized in that the application of the fastening element (2) to the substrate (1) and gluing it to the substrate (1) and/or clipping the component (4) onto the fastening element (2) is/are performed automatically by a robot.
16. The method according to any one of the preceding Claims 1 through 15, characterized in that the fastening element (2) is produced with a mushroom-shaped cross section.
17. The method according to any one of the preceding Claims 1 through 15, characterized in that the clip area (5) of the component (4) is produced with a mushroom-shaped cross section.
18. A clip-on fastening system in which a fastening element (2) that functions as the base part of the clip-on fastening system is joined in a non-positive manner to a substrate (1) and provides a detachable clip-on fastening of the substrate (1) to a component (4), in particular a gasket, which is provided with a clip area (5), whereby the fastening element has a cross-sectional shape that corresponds to the clip area (5) of the component, characterized in that a fastening element (2) which has been prefabricated and manufactured using a hard material to produce a hardened continuous profile in an extrusion process is

glued onto the substrate (1), and the component (4) is clipped with the clip area (5) onto the finished fastening element (2).